



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
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RBE350A93-3500-00

Job Sheet 197462



Part No: RBE350A93-3500-00

Job Qty: 18 pcs

Part Name: Bearing Extractor



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 7/9/19

Job Tracking No:

Created By: Marie Lajeunesse

Due Date: 9/2/19

Description:

Type: Stock

Note: DWG RBE350A93-3500-00 Rev 3A IPP Rev A 18.01.16 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Small Fab - 1	18 pcs	9/2/19		0.00	4.50	Small Fab - 1		MCC
							Small Fab - 2		
							Small Fab - 3		
							Small Fab - 4		
							Small Fab - 5		
							Small Fab - 6		
							Small Fab - 7		
120	QC 5	18 pcs	9/2/19		0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
							QC 5 - 30		
							QC 5 - 40		
							QC 5 - 61		
							QC 5 - 81		
130	Packaging 3-1 - Stock - B4B	18 pcs	9/2/19		0.00	0.00	Packaging 3 - 1 - B4B		
							Packaging 3 - 2 - B4B		
							Packaging 3 - 3 - B4B		
							Packaging 3 - 4 - B4B		
							Packaging 3 - 5 - B4B		



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CANADA
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www.dartaerospace.com

Container No: S201678



Part: RBE350A93 - 3500 - 00

Job No: 197462

Serial No/Batch: S201678

Revision: 3A

Inspector:

Exp Date:

Instructions:

Date: 07/30/19

DAS
40
9-89

JUL 31 2019

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				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
140 QC 21 - FG	18 pcs	9/2/19	0.00 0.00	QC 21 - FG - 21	
				QC 21 - FG - 70	
				QC 21 - SA - 53	

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Part Op 110 - (Small Fab) - Assemble as per DWG. Press fit dowels
 Descriptions: 120 - QC5- Inspect part completeness to step on W/O)
 130 - (Identify as per dwg & Stock Location: _____)
 140 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
91585A208	Dowel Pin M8 x 40mm	30-54 Ea (3 ea)	110-Small Fab - 1	5199,321
RBE350A93-3500-00-1	Body	10-18 pcs (1 ea)	110-Small Fab - 1	5176,898

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
110-Small Fab - 1	91585A208	54	45	0
	RBE350A93-3500-00-1	18	10	0

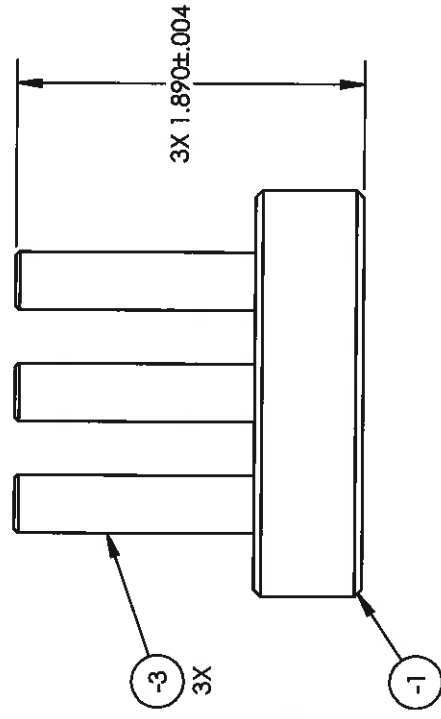
Part Specifications

Specifications could not be found.

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REVISIONS			
REV	DESCRIPTION	DATE	INITIAL
1	CHANGED PIN MATERIAL FROM 1018 RND. TO 304 S.S. BAR	5/27/09	WP
1A	-1 REMOVED REF. FROM B.C. Ø1.393 DIMENSION. ADDED (.6965) DIMENSION PER G.E.	9/15/11	RJC
2	VERIFIED AND CORRECTED -1 DIMENSIONS TO MATCH THE ORIGINAL DWG. REPLACED -3 PIN WITH DOWEL PIN. CHANGED ASSEMBLED PIN HEIGHT FROM 1.306 TO 1.890±.004 PER ORIGINAL DWG.	7/24/2012	RJC
3	CHD COUNTER BORE DEPTH WAS .323 IN .275. ADDED DWG. FOR -3 TO MODIFY DOWEL PIN.	4/18/2013	CFS
3A	CHD 1/4" WAS RBEA93-3500-00 IS RBE350A93-3500-00. CHD TOOL NAME WAS BEARING EXTRACTOR. HYDRAULIC PUMP IS BEARING EXTRACTOR.	11/6/2013	RJC



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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 197462 M5
1907-09

RED BARN MACHINE	
TITLE BEARING EXTRACTOR	
DWG NO. RBE350A93-3500-00	REV 3A
DRAWN BY: CLOUGH	
APPROVED: <i>D. Med</i>	
MATERIAL: UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES XXX ± .006 XX ± .01 X ± .1 TREAT FINISH SPEC	
1. BREAK ALL SHARP EDGES .016 x .45° 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
USED ON MODEL	EUROCOPTER 350A
SCALE 1:1	DATE 7/24/2012
SHEET 1 OF 3	

ASSY QTY	ASSY B/O QTY	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
		-1	1	BODY	6061	Ø2-1/4 X 3/4	2
		-3	3	DOWEL PIN	18-8	Ø8mm X 40mm MCMASTER-CARR #91585A208 (MODIFIED.)	3

Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____		DISPOSITION		DEPARTMENT/PROCESS																																																							
Date : _____		Sequence #: _____		QTY Affected : _____																																																							
Description Work Order Deviation		Disposition																																																									
Root Cause <table border="1"><tr><td>Operator</td><td></td></tr><tr><td>Manufacturing Process</td><td></td></tr><tr><td>Equip/Tooling</td><td></td></tr><tr><td>Handling/Preservation</td><td></td></tr><tr><td>Material</td><td></td></tr><tr><td>Product Improvement</td><td></td></tr><tr><td>Process Improvement</td><td></td></tr><tr><td>Human Factors</td><td></td></tr></table>		Operator		Manufacturing Process		Equip/Tooling		Handling/Preservation		Material		Product Improvement		Process Improvement		Human Factors		FAULT CATEGORY																																									
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Other/Details: _____																																																											
Completed By		MRB (QS1042)																																																									
Lead hand / Supervisor																																																											
QC / QA Coordinator																																																											